

5/38

DART AEROSPACE LTD	Work Order :	24092
Description: Step Extrusion	Part Number:	D2622-120C
04.04.21 05.02.10 CP		
Drawing: D2622 Rev. C1	Qty:	136 124 W
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	JS	05.08.23	124
2	PG	Issue P/O: <u>2008532</u> a) Extrude as per Dwg D2622 Rev. C 05.02.10 CP b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	AS	05/08/24	124
3	RG	Inspect for transit damage Ensure Certification are attached	CL	05/09/13	136
4	QC6	Inspect dimensions per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached. Check hardness with Webster tester	2	05.11.02	136
5	ST	Identify and Stock as D2622-120C	2	05.11.02	136
6	AC	Cost / part <u>24.17</u>	2	05-11-03	136
7	DC	Close W/O <u>Y, 13</u> Inspect Level 21	LP	05/11/03	136

Rev	Date	Change	Revised By	Approved
A	02.11.12	New Issue	KJ RF	JS

RELEASED
02.11.18 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

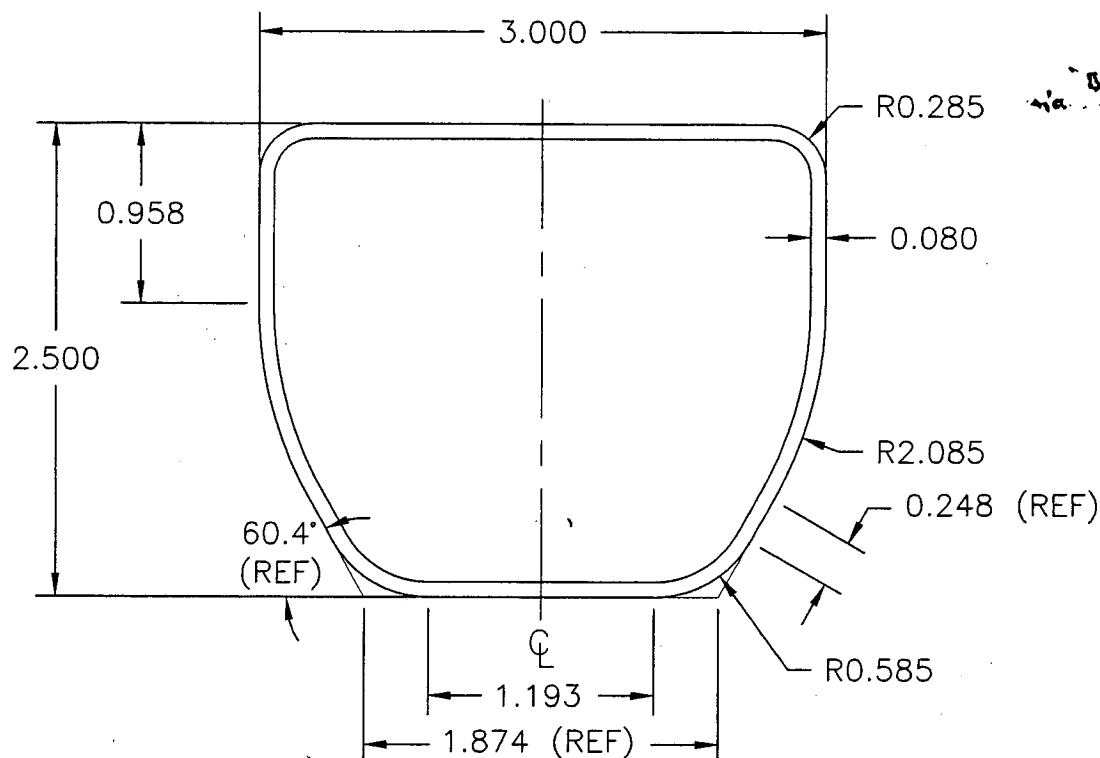
NCR: 24092		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-02	4	Damage on ends of extrusion up to 4" long on a qty of 4, and dents in center of 2 extrusions.		use damaged mat'l for start steps, and notify Bon L (supplier) of transport damage		2 05-11-02		2 05-11-02

Part No: D2622-120C PAR #: 2/11 Fault Category: Bon L NCR: Yes No DQA: Date: 05/11/03
 NOTE: Date & initial all entries QA: N/C Closed: Date: 05/11/03




RELEASED
02.09.11

DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
C.D. H GP	02.10.04	ADD 'REV. A' TO DIE NUMBER.	



1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES
(EG. D2622-120 IS 120" LONG)

2) MATERIAL 6061-T6 (QQ-A-200/8)

3) MANUFACTURED USING BON-L DIE # 897123 REV. A 

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

5) PART IS SYMMETRIC ABOUT CENTERLINE

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

WORK ORDER

NO. 24092

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024092
Project Name : D2622-120C
Project For : WK538
Work Order Type : Main
Main WO Number :
House Part Number : D2622-120C
Description : Extrusion
Manufactured : Yes
Amount Req'd : ~~110~~/2/
Amount Done : 0
Start Date : 08-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

THE WILLIAM L. BONNELL COMPANY, INC.
BON L MANUFACTURING COMPANY
 SUBSIDIARIES OF TREDEGAR CORPORATION
 FILIALES DE LA CORPORATION TREDEGAR

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HIL ON

BORDEREAU D'EXPEDITION

MANIFEST DATE/DATE D'EXPÉDITION

09-07-05

MANIFEST NUMBER/N° D'EXPÉDITION

465114

SALES ORDER NUMBER/N° DE COMM.

66812

SALES REP
REP. DES VENTES

**REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.**

CREDIT REP
REP. DU CRÉDIT
SMITH, JOANN
770-252-0161

FIELD SALES REP
REP. RÉGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP. SERVICE CLIENTÈLE
Burton D
905-427-2227

ACCT# 00046024

SHIP TO/EXPÉDIÉ À

BART AEROSPACE LTD.
 270 ABERDEEN ST.
 HAWKESBURY
 661K7

SOLD TO/VENDU À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

O/P

PHONE 613-632-3336

PHONE 613-632-3336

FORMER ID/N° DU CLIENT	ORDER DATE DATE DE LA COMMANDE	CUST. P.O. NO./N° DE COMM. DU CLIENT	JOB/PROJET
46024	08/26/05	2008532	

LOC/USINE	TRAILER NO./N° DE REMORQUE	SALESMAN/VENDEUR
RIH	83067	59358

BILL OF LADING NUMBER/N° DE CONNAISSANCE 00276719
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[illegible]

RM NO. B1065 REV. C
RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
LE RETOUR DE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER **CLIENT** **PAGE**

1

TOTALS/TOTAUX

STOMES ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION/RECONNAISSANCE DU CLIENT DU MATÉRIEL LIVRÉ ET DE SA CONDITION

DATE OF DELIVERY/DATE DE LIVRAISON: _____

DRIVER/CAMIONNEUR:IR

**BON L CANADA INC**500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No	Sales Order	Page
09/07/05	127011	66812	1
Cust PO	B/L No	Lot	Date
2008532	00276719	66812010	9/07/05

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	581 KGS
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Net Qty	559 KG	136 PC	415 M	2 PKG
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Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	303.5 / 44.0	275.9 / 40.0	10.8	.0	90
2	307.6 / 44.6	278.0 / 40.3	10.3	.0	91

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.666	.277	.283	.059	.885	.058	.005	.074	.000	.010	.017	.000	.000
.668	.242	.267	.052	.887	.055	.005	.062	.000	.009	.015	.000	.000
.634	.257	.256	.048	.873	.068	.005	.075	.000	.009	.016	.000	.000

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Paul Dailleboust, QA Manager Signed for Bon L Canada